

Docket No. 109769.0001

### AMENDMENTS TO CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:  
Please delete claims 6 and 12 from the application without prejudice or disclaimer.

1. (currently amended) A negative diopter lens for use as an ophthalmic lens which is substantially stress-free by absence of fringes when analyzed with a strain tester, said lens being formed from an acrylic resin material by the steps of:

providing an injection molding machine having a mold clamp, a mold material injection screw, and two mold plates with at least one mold cavity between the plates, wherein the injection molding machine is operatively controllable to exert variable clamping pressure against at least one of the two mold plates;

preparing the injection molding machine for operation with an acrylic resin molding material by inputting control parameters into a control system, the control parameters including:

plastic temperature, plastic flow rate, plastic pressure, plastic cooling rate, clamp closing velocity, velocity-pressure changeover position and coining stroke;  
initiating a mold process by closing the mold plates together under a specified primary clamp pressure;

advancing the injection screw to partially fill the mold cavity with acrylic resin material and to reach a VP changeover position;

applying a secondary clamp pressure greater than the primary clamp pressure to perform a coining operation on the acrylic resin material in the mold;

holding the injection screw according to time and pressure control parameters;  
advancing the injection screw according to packing time and pressure control parameters;  
allowing the acrylic resin material to solidify and cool;

separating the mold plates; and  
ejecting the negative diopter lens out of the mold cavity;

the lens having an impact resistant strength sufficient to pass a standardized impact test ANSI Z80.1-1995.

Docket No. 109769.0001

2. (original) The lens of claim 1 wherein said acrylic resin is polymethylmethacrylate.
3. (original) The lens of claim 1 wherein molecules of the acrylic resin material are substantially aligned throughout the lens.
4. (original) The lens of claim 1 wherein a substantially uniform stress level exists throughout the lens.
5. (original) The lens of claim 1 having a diopter in an approximate range of -0.25 to -1.50.
6. (canceled).
7. (currently amended) A negative diopter lens for use as an ophthalmic lens which is substantially stress-free, the lens being formed from an acrylic resin material by a process comprising the steps of:
  - providing an injection molding machine having a mold clamp, and a mold injection screw, at least three mold plates wherein at least one mold cavity is formed between at least two of the three plates, wherein the injection molding machine is operatively controllable to exert is variable clamping pressure against at least one of the at least three mold plates;
  - preparing the injection molding machine for operation with an acrylic resin molding material by inputting control parameters into a control system, the control parameters including:
    - plastic temperature, plastic flow rate, plastic pressure, plastic cooling rate, clamp closing velocity, velocity-pressure changeover position, and coining stroke;
  - initiating a mold process by closing at least two of the at least three mold plates together under a specified primary clamp pressure;
  - advancing the injection screw to partially fill the mold cavity with acrylic resin

Docket No. 109769.0001

material and to reach a VP changeover position;  
applying a secondary clamp pressure greater than the primary clamp pressure, to  
perform 25 a coining operation on the acrylic resin material in the mold cavity;  
holding the injection screw according to time and pressure control parameters;  
advancing the injection screw according to packing time and pressure control parameters;  
allowing the acrylic resin material to solidify and cool;  
separating two of the at least three mold plates; and 5 ejecting the negative diopter  
lens out of the mold cavity;  
the lens having an impact resistant strength sufficient to pass a standardized impact  
test ANSI Z80.1 -1995.

8. (original) The lens of claim 1 wherein said acrylic resin is  
polymethylmethacrylate.

9. (original) The lens of claim 1 wherein molecules of the acrylic resin material are  
substantially aligned throughout the lens.

10. (original) The lens of claim 1 wherein a substantially uniform stress level  
exists throughout the lens.

11. (original) The lens of claim 1 having a diopter in an approximate range of -  
0.25 to -10.00.

12. (canceled).

Docket No. 109769.0001


CONCLUSION

In view of the foregoing, it is respectfully submitted that all claims are patentably distinct over the art of record and in condition for allowance thereof. If the Examiner believes there are any further matters that need to be discussed, the Examiner is invited to contact the undersigned.

If there are any other fees necessitated by the foregoing communication, please charge such fees to our Deposit Account No. 50-0959, referencing our Docket No. 109769.0001.

Respectfully submitted,  
ROETZEL & ANDRESS

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